

**Aero Design Ltd.****Work Order Control Sheet****Work Order#:** 2014-83 **Date Opened:** 20 Oct 2014 **Title:** Fabrication**Aircraft OEM:** Eurocopter **Aircraft Model:** AS350/355 **Product Type:** Cargo Basket **Product Model:** Ski **Quantity:** 3**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification (Original)  
Time Sheet (R&D)  
Notes

Initial or N/A

JR
N/A
JR
JR
JR
N/A
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JR
JR

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
94023	0	Mount Hoop	JR
94010	0	Basket	JR
94011	0	Body	JR
94012	0	Lid	JR
94027	0	Data Plate	JR
94030	0	Attachment Hoop	JR

**Traveller**

Install walkway on lid  
Install lid on basket body  
Re-tap mounting lug holes and install mount lugs  
Install handle brackets  
Install handle  
Install lid prop  
Install data plate

Initial or N/A

JR
JR
JR
JR
JR
JR
JR

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

3
N/A
N/A
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Tracking (White) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
N/A
N/A
JR
N/A

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JR
N/A
N/A

Work performed by:

Print: J Rekve for M Rekve

Sign: \_\_\_\_\_

SCA: AD01Date: 30-Oct-14

ICC / Dual Inspection performed by:

Print: Jason Rekve

Sign: \_\_\_\_\_

SCA: AD01Date: 30-Oct-14

Work Order closed by:

Print: Jason Rekve

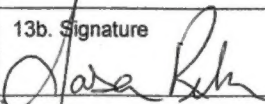
Sign: \_\_\_\_\_

SCA: AD01Date: 30-Oct-14

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE <b>FORM ONE</b>			3. Form Tracking No.	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO2014-83</b>	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	<b>Cargo Basket</b>	<b>94010-01</b>	<b>1</b>	<b>94001-37</b>	<b>New</b>	
12. Remarks <b>Modified with walkway on lid IAW DCL704, black</b>						
13a. Certifies that the items identified above were manufactured in conformity to:				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.				<input type="checkbox"/> Other regulation specified in block 12		
<input type="checkbox"/> Non approved design data specified in block 12.				Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number
13d. Name <b>Jason Rekve – AD01</b>		13e. Date (dd/mmm/yyyy) <b>17 Dec 2014</b>		14d. Name		14e. Date (dd/mmm/yyyy)
<b>Installer Responsibilities</b>						
This certificate does not constitute authority to install.						
Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.						
Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.						

Arrow



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: HALF HOOP (AMAR SHE) No. of pieces: 6

Manufacturer: AERO DRS 26N

Part No.: 94023-01 Serial / Batch No.: 14009, 12123

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2014-83

Remaining Tasks to be Performed: weld to 1" hoop

Signature: [Signature]

Date: Oct 30, 2014 Lic. No. / SCA: AD06

In Process



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9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: ASAR MANT HOOP No. of pieces: 5

Manufacturer: AERO DESIGN

Part No.: \_\_\_\_\_ Serial / Batch No.: \_\_\_\_\_

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2014-83

Remaining Tasks to be Performed: \_\_\_\_\_

Signature: \_\_\_\_\_

Date: Oct 2014 Lic. No. / SCA ADDG.

In Process





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: ASDAR XL HOOP No. of pieces: 14

Manufacturer: AERO DESIGN

Part No.: 94030-01 Serial / Batch No.: 14009

TTSN: V/A TSO: N/A Rem.: N/A

Work Order No.: 2014-83

Remaining Tasks to be Performed: Remove writing, Dig into  
bucket

Signature: [Signature]

Date: Oct 30, 2014 Lic. No. / SCA 9006

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

Remarks

In Process

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## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

No. of pieces:

81 59 DRM

Nomenclature: Spacer

Manufacturer: AERO Design

Part No.: 49215-01

Serial / Batch No.:

8096

TTSN: N/A

TSO: N/A

Rem.: N/A

Work Order No.: 2014-39

Remaining Tasks to be Performed: FACE ON LATHE done AD-05

Signature: [Signature]

Date: April 8, 2014

Lic. No. / ACA AD06

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

### Remarks

In Process

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2014-83

AS350 XL

## CARGO BASKET BODY FABRICATION - COMMON

### General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407** – Right side only

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

*Options* 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

#### **Eurocopter AS350/AS355** – left or right

77611, Revision 1 – Short Basket

76411, Revision 3 – Medium Basket (left or right)

78411, Revision 2 – Long Basket

→ 94011, Revision 0 – Extra Large (ski) Basket

*Options* 70406, Revision 2 – Front end cutout – 764/776/784/940

#### **Robinson R44** – left or right

90611, Revision 0 – Standard Basket (left or right)

#### **Bell 206B** – right side only

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

*Options* 70406, Revision 2 – Front end cutout – 802/803/811

#### **Bell 429** – right or left

95911, Revision 0 – Standard Basket

#### **Bell Medium** – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

*Options* 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

#### **MD600**

82811, Revision 0 – Standard Basket

#### **Options** – Applicable to all models

70403, Revision 5 – Auxiliary Latch

## CARGO BASKET BODY FABRICATION - COMMON

Complete  
(initial or SCA #)

Work Order: 2014-83

Date Open: \_\_\_\_\_

### 1. Rim Assembly – Basket Body

ML

- a. Cut and fit  $\frac{3}{4}$ " x 0.035 material to fit rim jig.
  - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

### 2. Weld Rim Assembly.

AD-05

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

### 3. Inspection

ML

- a. Rim for complete welds

### 4. Frame assembly – body

ML

- a. General
  - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock - standard, attachment, handle.
  - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
  - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
  - i. Ensure correct order and orientation of hoops. Refer to drawing.
    1. Attachment lugs are on inboard side.
    2. Handle bracket bushings are on outboard side, second hoop from both ends.  
May be on attachment hoops.
  - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
  - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
  - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
  - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut  $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut  $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
  - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut  $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut  $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
  - i. Extra large baskets
    - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
    - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
    - 3. forward and aft hoops align to INSIDE of rim
  - ii. All other baskets
    - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
    - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
    - 3. forward and aft hoops align to INSIDE of rim, except R44

## 5. TIG weld frame to rim assembly.

AD-05

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

## 6. Inspection

NA

- a. Frame assembly for complete welds.

## 7. Mesh assembly.

NA

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
  - i. For extra wide baskets only –
    - 1. Set  $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
    - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
    - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
  - ii. Using markings on table, align sheet to indicated edge.
  - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
  - iv. Bend mesh by hand tightly over tube along length of tube.
  - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
  - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.



- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
  - i. General
    - 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
    - 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
    - 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
    - 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
  - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
  - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
  - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
  - v. Clamp mesh to spine in at least 1 place per section.
  - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
  - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
  - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
  - i. Remove surface rust with scotch-brite.
  - ii. Ensure mesh is cut at intersections where possible.
  - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
  - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
  - i. Remove surface rust with scotch-brite.
  - ii. Ensure mesh is cut at intersections where possible.
  - iii. Bend top edge of mesh 1/4" down at 60 degrees.
  - iv. Fit mesh to front end of basket.

## CARGO BASKET BODY FABRICATION - COMMON

Complete  
(initial or SCA #)  
AD-05

### 8. Weld mesh to frame assembly per drawing.

- a. Ensure lug locating jig is in place prior to welding.
- b. General welding requirements for all baskets, MIG welding:
  - i. Every intersection at top edges.
  - ii. Every intersection at ends.
  - iii. First 5 intersections down on hoops, then every second intersection.
  - iv. Every intersection along spine.
  - v. Extra large baskets – every intersection along corner.
  - vi. Every intersection around ends
  - vii. Every intersection along struts (if applicable)
- c. Bend and trim cells bent in to fit mesh as required and weld in position.
- d. Grind high spots off body mesh welds on ends before welding end mesh.
- e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
- f. Record welding rod PO on attached material list.

### 9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
  - i. Record welding rod PO on attached material list.
  - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
  - i. Cut inboard rim on aft end. Grind flush with hoops.
  - ii. TIG weld caps on open tubes.
  - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
  - i. Record welding rod PO on attached material list.
  - ii. Record placard bracket WO on attached material list.

AD-05

### 10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

HK

### 11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
  - i. Hoops for height.
  - ii. Rim for width and length and alignment.
  - iii. Lid prop lugs in correct ends.
  - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

AK



## CARGO BASKET BODY FABRICATION - COMMON

Complete  
(initial or SCA #)



- e. Tag complete basket body assembly in preparation for powder coating.

### 12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.

## CARGO BASKET HOOP FABRICATION - 94023

### General

These instructions apply to cargo basket attachment hoop 94023-01. Refer to the following drawings, at the current revision, for dimensions and details:

94023, Revision 0 – Attachment Hoop

84262, Revision 1 – Handle Bracket Assembly

Work Order:

2014-83

ASTAR SKE

Complete

(initial or SCA #)

Date Open:

20-Oct-14

#### 1. ½ Hoop Fabrication – ½" hoop

ADUG

- a. Cut ½" x 0.035 material to 23.0", square ends.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ??"
  - ii. Lower bend stop: 12mm
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- j. Check for:
  - i. hoop height: 18" (Outside to outside)
  - ii. adjust upper stop for height if required

#### 2. ½ Hoop Machining – ½" hoop – Handle Provisions 84262-01

ADUG

- a. Start with ½" half hoop from step 1.
- b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
- c. Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
  - i. locate 0.23" from edge (within tolerance specified on drawing).
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Tag in process hoop(s) and place into stock.



## 3. ½ Hoop Fabrication – 1" hoop

- a. Cut 1" x 0.065 material to 30.0", on end square, one end @ 16 degrees.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ??
  - ii. Lower bend stop: ??
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for angle using hoop jig. Adjust stops if required.
- j. Check for:
  - i. hoop height from jig
  - ii. adjust upper stop for height if required
  - iii. length to allow 60 degree cut.
- k. Using hoop jig, mark for 60 degree cut on bottom end. Cut to length.
- l. De-burr cut end using a sanding disc on a die-grinder or disc sander.

## 4. ½ Hoop Machining – 1" hoop



- a. Start with 1" ½ hoop as stock.
- b. Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.75" and set X 0. Shift Y -0.5". Set stop against end of tube.
- c. Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Set tube in vise with 60 degree end on right.
- f. Using ½" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
- g. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- h. Tag in process hoop(s) and place into stock.

## 5. Joint Preparation



- a. Set 1" hoop in hoop jig. Insert ½" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto ½" hoop. Trim ½" hoop with vertical bandsaw if required, and shape to match slot with disc sander.
- b. Insert one 94023-05 lug (flat end) at top and 94023-07 lug (angled end) at bottom into holes in 1" hoop. Seat top lug flush with inboard face of tube using a C-clamp or vise. Attach 16 7/8" spacing jig with 3/8-24 bolts to lugs and space jig 7/8" out from hoop. Mark 94023-07 lug and trim or grind to fit.

AD-05

## 6. Welding – Lugs

- a. Insert one 94023-07 lug (flat end) at top and 94023-05 lug (angled end) at bottom into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 16 7/8" spacing jig with 3/8-24 bolts to lugs and space jig 7/8" out from hoop.
- b. TIG weld all around both sides of lugs. 2 places. Grind angled lug into radius of hoop before welding.
- c. Record lug and welding rod PO/WO on attached material list.

## 7. Welding – Handle Bushings – 84262-01

AD-05

- a. Insert 84271-01 bushings into 1/2" hoop prepared in step 2. above.
- b. TIG weld bushing both sides, 2 bushings per hoop.
- c. Record bushing and welding rod PO/WO on attached material list.

## 8. Welding – Hoop Assembly

AD-05

- a. Insert 1" hoop from step 6 and 1/2" hoop from step 7 into hoop jig. Seat 1/2" hoop into slot in 1" hoop.
- b. Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
- c. TIG weld around 1/2" hoop in slot.
- d. Cap 1/2" – 1" tube joint with 76423-04 cap. TIG weld around cap.
- e. Record cap and welding rod PO/WO on attached material list.

## 9. Finishing and Inspection

AD

- a. Run 3/8-24 tap through welded lugs.
- b. Grind inside surfaces flush at lugs and slot in 1" tube.
- c. Inspect hoop for conformity to drawing.
- d. Tag complete and inspected hoop(s) and place into stock.

Work Order: 2014-83

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Basket Body Fabrication

1 of 2

Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
		94011	94011-01	<b>Basket Assembly</b>		
<b>Step 1</b>				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14609
	. 2		--	3/4" Tube - Short Rim (25.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	13087
	. 1		--	3/4" Tube - Long Stringer (95.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14609
	. 4		--	3/4" Tube - Short Stringer (2.25")	4130 Steel, 3/4" x 0.035 Sqr. Tube	13087
<b>Step 2</b>				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033
<b>Step 3</b>				<i>Inspection - Rim</i>	None	
<b>Step 4</b>				<i>Frame Assembly</i>		
	. 4		94030-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	2014-40
	. 2		94023-01	Hoop - attachment		2014-57
	. 5		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	14060
<b>Step 4.g.</b>		70406	70406-01	<i>Option: Front End Cutout</i>		
			70406-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	
			70406-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	
<b>Step 5</b>				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033
<b>Step 6</b>				<i>Inspection - Frame Assembly</i>	None	
<b>Step 7</b>				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 56" x 96")	3/4-16F Expanded Mild Steel sheet	14012
	. 2		--	Mesh (End - 25" x 18")	3/4-16F Expanded Mild Steel sheet	14012



Work Order: 2014-83Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Basket Body Fabrication

2 of 2

Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
<b>Step 8</b>				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	14028
<b>Step 9</b>				<i>Weld Basket Components</i>		2015-07 (2)
	. 2		49215-01	Spacer (Lid prop)	304 Stainless Steel, ½" Dia.	2014-39 and PO#14092
	. A/R		--	Welding Rod	ER308L TIG Rod	14028
<b>Step 10</b>				<i>Clean Up</i>	None	
<b>Step 11</b>				<i>Inspection - Final Assembly</i>	None	
<b>Step 12</b>				Powder Coating		



Aero Design Ltd.

Type: AS350 SK1

Work Order: 2014-83

Task	By	Notes	Date
LID MESH TO 12065			
LID WALKWAY 1/2" 14060			
LID CROSSMEMBERS 14009			
LID ENDS 14009			
LID RIM 14009			
1/2 hoop 12123, 14009			
STANDARD HOOP 14009			
Handle bushing S. wdt 2014-26			
BODY RIM ENDS 13061 47" + 95" 14009			
BODY CROSSMEMBERS 1211			
SPINE 14009			
mount hoops x4 2014-30			
BODY MESH 14012			
MESH ENDS 14012			



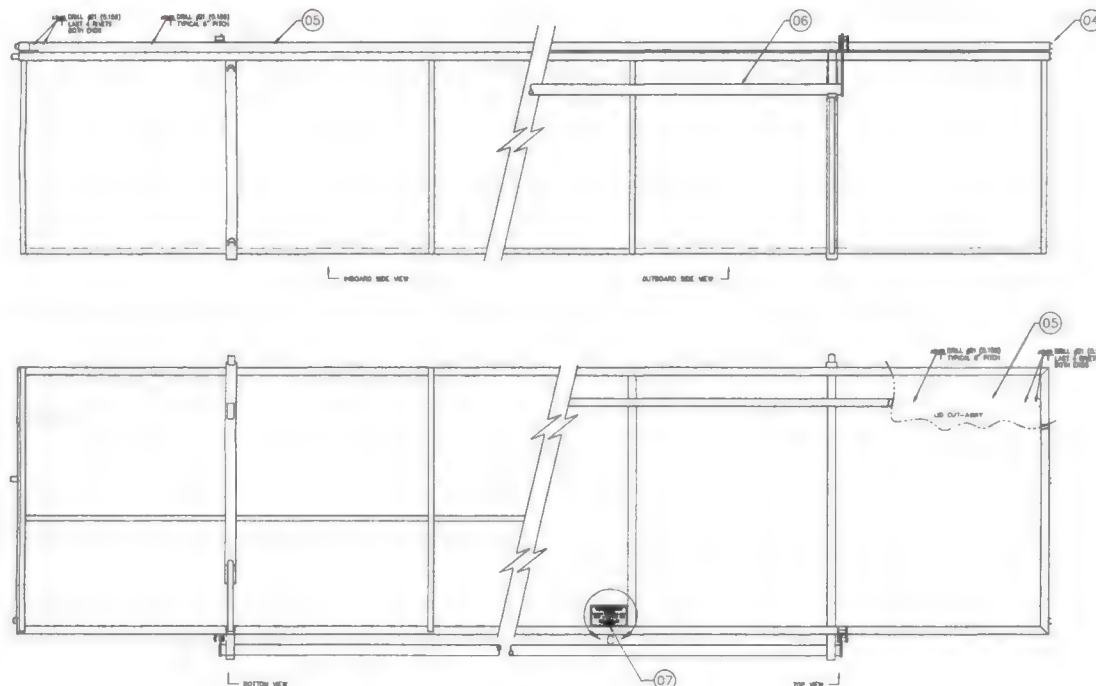
WO# 2014-83

Approved Manufacturing Facility 73-04

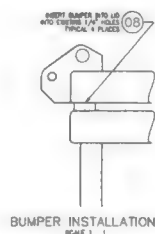
Form 20.F.06

Rev. Original 27 May 2013

2014-83 x5



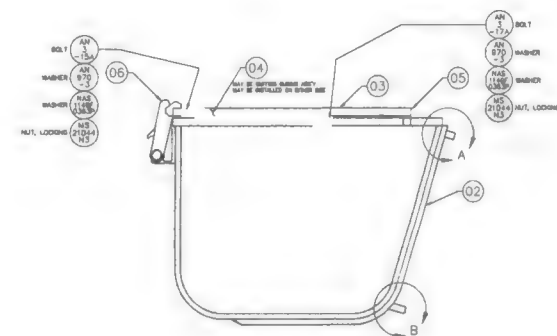
940  
10  
-01 CARGO BASKET ASSEMBLY - RH



## BUMPER INSTALLATION



DETAIL C  
SCALE 1" = 1'  
LOOKING AT PLACARD BRACKET



DETAIL A

SCALE 1 2  
TYPICAL FRONT AND REAR

DETAIL 8

SCALE 1 : 3  
TYPICAL FRONT AND REAR

NOTE  
1. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS

2	MS27-00-1	BOLT	WOODING			
1	MS27-00-2	WASHER				
2	MS27-00-3	WASHER				
1	MS27-00-4	BOLT				
1	MS27-00-5	BOLT				
1	MS27-00-6	BOLT				
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STAIN

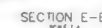
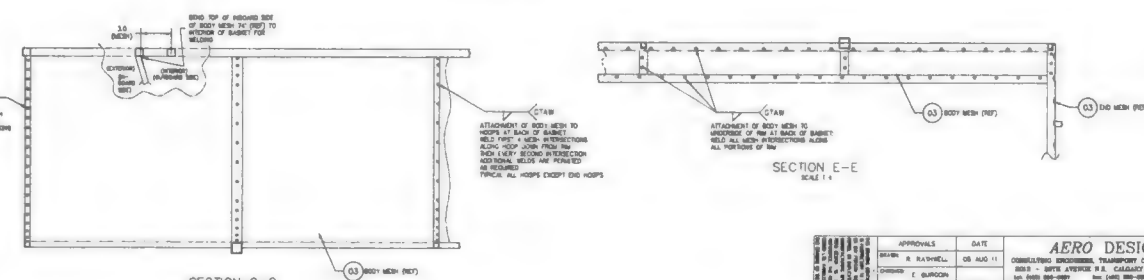
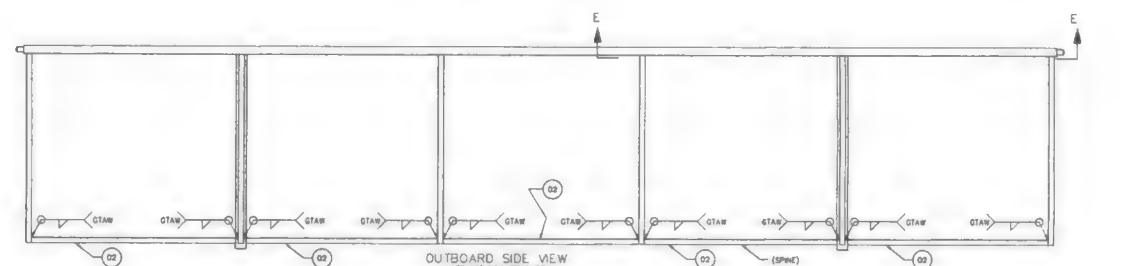
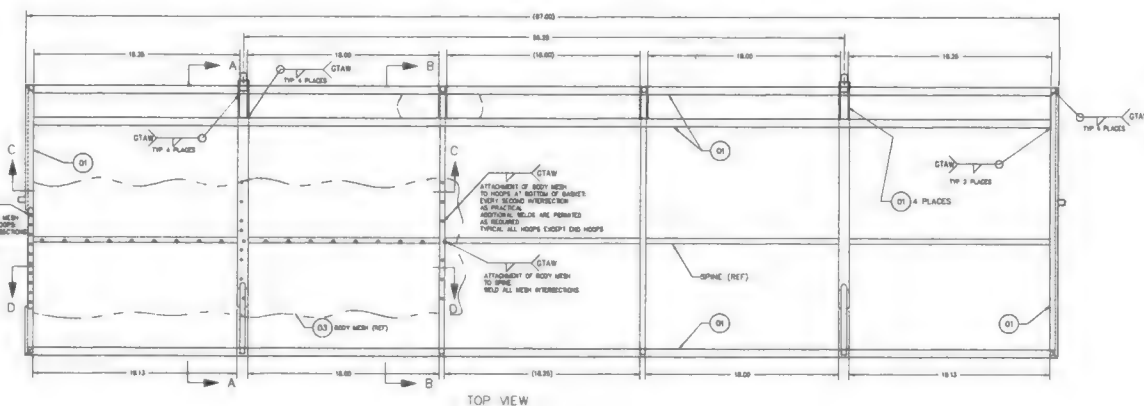
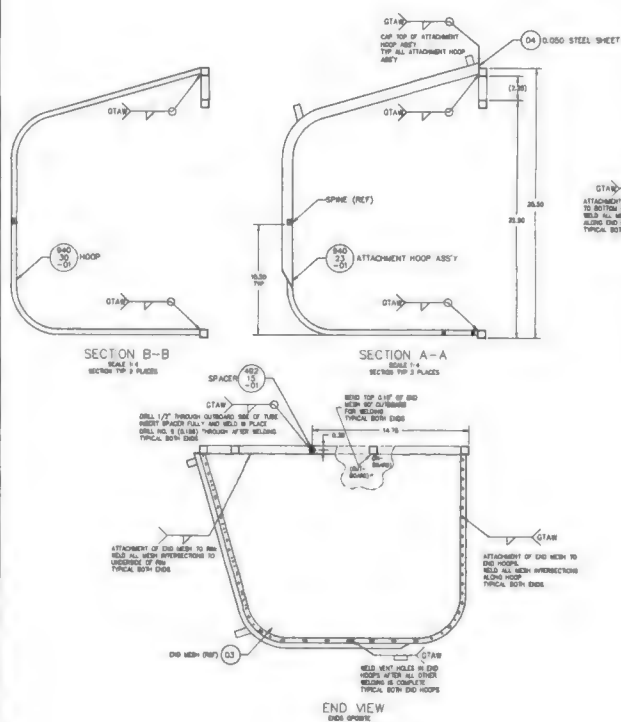
ATTACHMENT OF BODY MESH TO OUTBOARD OF END HOOPS  
WELD FIRST A NEW INTERSECTION ALONG END HOOP  
PHYSICAL BODY DIME

SECTION D-D

SCALE 1/4" = 1'-0"

NEW LOOKING OUTBOARD

BODY MESH (REF)

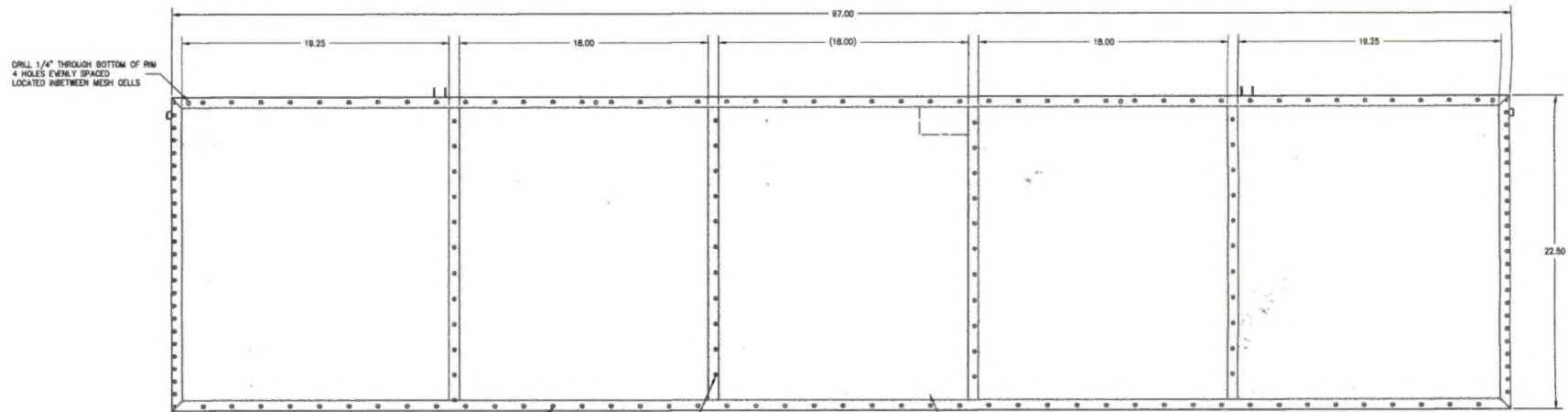


- NOTES
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
  2. PRIOR TO WELDING, DRILL 1/16" VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WELD ASSEMBLY IS COMPLETE. FILL ALL VENT HOLES WITH ROSETTE WELD.
  3. BENDING OF 4130 STEEL TO BE COMPLETED BY STAMP METHOD TO ANG 285C.
  4. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
  5. FINISH THOROUGHLY CLEAN AND PRIMER COAT BASKET WELDS ASSEMBLY

[illegible][illegible]



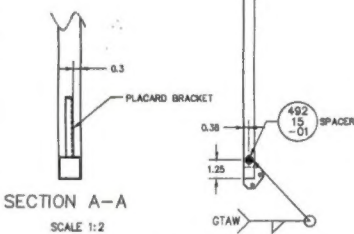
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



GTAW TYP  
ATTACHMENT OF MESH TO RM:  
WELD EACH INTERSECTION

GTAW TYP  
ATTACHMENT OF MESH TO CROSS MEMBERS:  
WELD EVERY SECOND INTERSECTION  
ADDITIONAL WELDS ARE PERMITTED  
AS REQUIRED

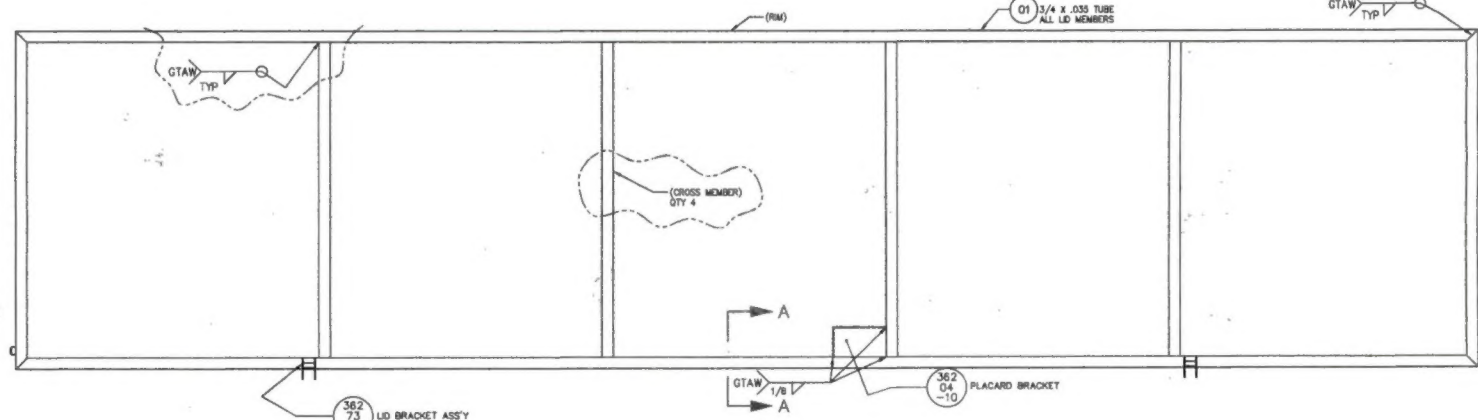
BOTTOM VIEW



SECTION A-A  
SCALE 1:2

DRILL 1/2" THROUGH OUTBOARD SIDE OF TUBE  
INSERT SPACER FULLY AND WELD IN PLACE.  
DRILL NO. 9 (0.180) THROUGH AFTER WELDING  
TYPICAL BOTH ENDS

END VIEW



362  
73  
-01  
LID BRACKET ASSY

INSTALL LID BRACKET ASSEMBLY  
IN ACCORDANCE WITH AERO DESIGN LTD.  
DRAWING 8402  
TYPICAL 2 PLACES

TOP VIEW

#### NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. PRIOR TO WELDING, DRILL 1/16" VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS 2585C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
4. FINISH: THOROUGHLY CLEAN AND POWDER COAT LID WELDED ASSEMBLY.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL/NOTE	MATERIAL SPEC	STOCK SIZE
1	36204-10		PLACARD BRACKET			
2	36273-01		LID BRACKET ASSY			
2	49216-01		SPACER			
A/R	3/4 - 16F	02	MESH	STEEL	STEEL	
A/R	4130	01	SQUARE TUBE	4130 STEEL CONG. H	ML-T-8736	0.75 X 0.035 SQR TUBE
A/R	84012-01		LID ASSEMBLY			
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL/NOTE	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

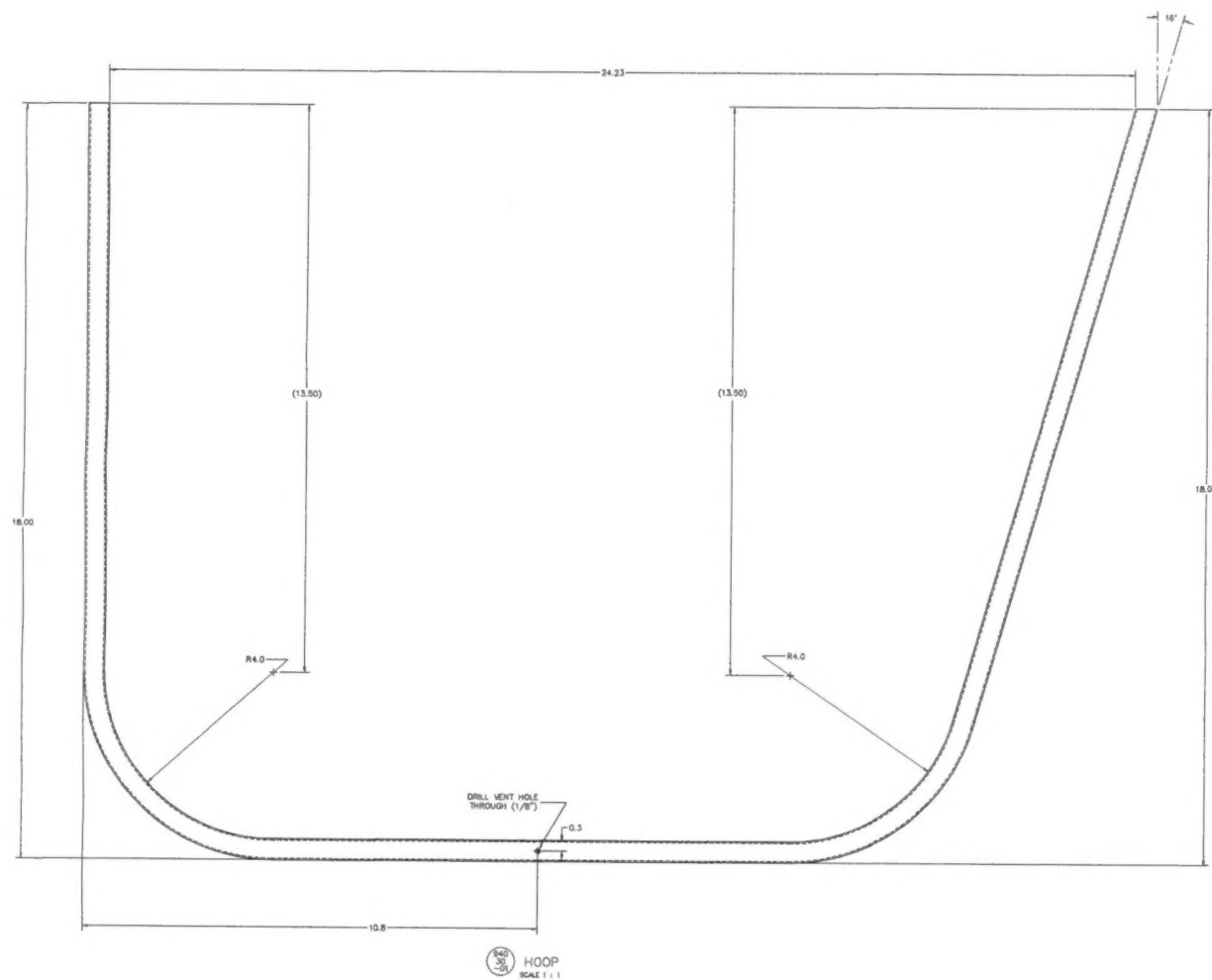
UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
XXX ±0.010 ±1/2°  
XX ±0.03  
X ±0.1

APPROVALS	DATE
DRAWN: R. RATHWELL	05 AUG 11
CHECKED: C. BURGOIN	

<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 2800 2015 - 30TH AVENUE N.E., CALGARY, ALBERTA, CANADA T2E 6R7 tel: (403) 950-9087 fax: (403) 950-8553 www.aerodesign.ca			
AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET LID ASSEMBLY			
SCALE 1: 4	DWG. NO.	DWG. NO.	REV.
SHEET 1 OF 1	A1	94012	0



REVISIONS		DESCRIPTION OF CHANGE	REVISED	DATE
1.		INITIAL ISSUE		



NOTES  
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

PART NO.		DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE
4130-01		HOOP	4130-01	4130-01	0.5 X 0.5 X 0.5
QTY		LIST OF MATERIALS			
APPROVALS		DATE			
DRAWN		08 AUG 11			
CHECKED		E. BURTON			
UNLESS OTHERWISE SPECIFIED		DIMENSIONS ARE IN INCHES			
TOLERANCES ON		DIMENSIONS			
FRACTIONS		±0.010			
DECIMALS		±0.003			
ANGLES		±1/2°			
SCALE		1:1			
SHEET		1 OF 1			

**AERO DESIGN LTD.**

CONSULTING ENGINEERS, TRANSPORT CANADA APPROVED CAR BASKET  
2015 - 2016 APPROVED P.E. CALGARY, ALBERTA, CANADA, T2E 0Y7  
403-240-8888 FAX 403-240-8888 www.aerodesign.ca

AS350 & AS355 SERIES  
QUICK RELEASE CARO BASKET  
ATTACHMENT HOOP ASSEMBLY

SCALE 1:1  
SHEET 1 OF 1  
A0 94030 0

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		

# NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:  
"QUICK RELEASE BASKET" - 0.125 HIGH  
"EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH  
"S/N 94001-XX" - 0.080 HIGH  
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH  
"300 LBS/136 KG" - 0.200 HIGH  
"AERO DESIGN LTD." - 0.125 HIGH  
"CALGARY, ALBERTA, CANADA" - 0.080 HIGH  
"403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)  
4 PLACES



01 PLACARD

94027-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

## LIST OF MATERIALS

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	DRAWN: R. RATHWELL		OCT 3, 2011						
	CHECKED: E. BURGOIN				<b>EUROCOPTER AS350 &amp; AS355 SERIES LARGE QUICK RELEASE CARGO BASKET PLACARD</b>				
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1								
		SCALE 1 : 1		DWG. SIZE		DWG. NO.		REV.	
		SHEET 1 OF 1		A1		94027		0	